

Work Order ID 132888

Thursday, May 14, 2015 7:47:31 AM

132888

Page 1

Item ID: D3296-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Replacement Interior Door For -111
 Start Date: 5/14/2015 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 5/14/2015 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: MLC Date: MAY 14 2015 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3296	B								
100		0.00							
100	Small Fab								
Small Fab	Memo	0.04							
Small Fab	Fabricate & assemble as per Dwg D3296.								
	Transfer drill using DT8470 & DT9521								
110		0.00							
110	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									
120		0.00							
120	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3								
Powdercoat	Memo	0.01							
Powder Coating	START TIME: <u>7:50</u> OVEN TEMPERATURE: <u>8:20</u>								
	FINISH TIME: <u>8:20</u>								

8X 15/05/14 DAS 36 9-89

(8) MAY 19 2015 DAS 36 9-89

8 d 15-5-21 DAS 36 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>ST436</u>	0.00			DA8 27 8-89	<u>8</u>	<u>15</u>		
160									
Packaging	Memo	0.00							
Packaging									MAY 26 2015
170	QC21- Final Inspection - Work Order Release	0.00							
170						<u>MLJ</u>			MAY 28 2015
QC	Memo	0.01							
Quality Control									

MLJ MAY 28 2015



Work Order update only

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework Scrap Use-as-is Suspected Unapproved		AGAINST DEPARTMENT/PROCESS Skid-tube Machining Thermoforming Large Fab Cross tube Small Fab Finishing Composite Water Jet Prod. Eng. Coord. Rec/Store/Packaging Supplier Engineering Quality Other					
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		OTHER :							

Picklist Print

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Parent Item: D3296-041

D3296-041

Parent Item Name: Replacement Interior Door For -111

Start Date: 5/14/2015

Required Date: 5/14/2015

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP C05.10.14Added step 14KJ/EC
IPP Rev:D Revised Steps 06-11-20 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3161-7 *D3161-7* Hinge 14.0"		Manufactured	No			100	Each	8.0000	1	8		15/05/14	DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST487				8					
				129947				8		7			
D3161-9 *D3161-9* Hinge 17.0"		Manufactured	No			100	Each	3.0000	1	8		15/05/14	DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST487				3					
				130071				3		2			
D3296-1 *D3296-1* Door Panel		Manufactured	No			100	Each	18.0000	1	8		15/05/14	DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST489				18					
				120422				10		8			
				130486				8					
D3296-3 *D3296-3* Door Panel		Manufactured	No			100	Each	19.0000	1	8		15/05/14	DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST233				11					
				129334				11		8			
				ST489				8					
				130487				8					

DQA: _____ Date: _____



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D3296-041

Parent Item Name: Replacement Interior Door For -111

Start Date: 5/14/2015

Required Date: 5/14/2015

Start Qty: 8.00

Required Qty: 8.00

MS20470AD4-6

Purchased

No

100

Each

2,029.000

1

8

15/05/25 68-6 96 DAS

MS20470AD4-6

RIVET

Location

Loc Qty

Loc Code

CCK004

2029

m131618

2029

8

D2137

Manufactured

No

140

Each

16.0000

1

8

15/05/25 68-6 96 DAS

D2137

Decal(No Step)

Location

Loc Qty

Loc Code

GA

4

115783

1

120383

3

2

ST006a

12

129911

12

6

D2419

Manufactured

No

140

Each

3.0000

1

8

15/05/25 68-6 36 9-89 DAS

D2419

Handle

Location

Loc Qty

Loc Code

GA

3

129862

3

5

3

D2462

Manufactured

No

140

f

477.8000

2.8166

23

15/05/25 68-6 36 9-89 DAS

D2462

Neoprene Seal (\$Per foot)

Location

Loc Qty

Loc Code

CA2

0.8

48530

0.8

ST638

477

115832

477

23

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Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Page 3

Work Order ID: 132888

132888

Parent Item: D3296-041

D3296-041

Parent Item Name: Replacement Interior Door For -111

Start Date: 5/14/2015

Required Date: 5/14/2015

Start Qty: 8.00

Required Qty: 8.00

D2728-1 Manufactured Yes

140 Each 0.0000 0 0

D2728-1

Dart Logo Label Small

MS20470AD4-4

Purchased No

140 Each 806.0000 25 200

MS20470AD4-4

Rivet, Universal Head

**

**

15/05/25
15/05/14
DAS 36 9-89
DAS 36 9-89

Location

Loc Qty

Loc Code

GA

144

M130224

144

ST309

649

M131800

649

ST310

13

118614

13

NAS1149DN632J

Purchased No

140 Each 90.0000 1 8

NAS1149DN632.J

Washer

**

15/05/25
DAS 36 9-89

Location

Loc Qty

Loc Code

ST270

90

M127255

41

M128812

49

8

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER : _____			